Work Order ID 69429

Wednesday, May 11, 2011 9:51:10 AM

Item ID: D2221 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: 350 Basket Base

Start Date: 5/11/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 5/13/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** 11-05-11 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2221	Rev H

100 0.00

Large Fab

Large Fab

Large Fab

Memo 0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: M117884

PLEASE NOTE
IF MAKING -041A OR -043A :
DRILL HOLES FOR GAS SPRING
IN D3825-041 AS PER
DSI 9473

QC 11.08.09

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Quality Control

Memo 0.00

11.08.10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	**Memo**	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing									

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat	Memo	0.00							
Powder Coating	~~1~~ Plug holes prior to								
	1ST COAT:								
	START TIME: 11:45Am								
	OVEN TEMPERATURE: 400°F								
	FINISH TIME: 12:15pm								
	********** 2nd coat if necessary**********								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
140	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location G-A	0.00							
Packaging									
Packaging	**Memo** w/o 69426	0.00							
160	QC21- Final Inspection - Work Order Release	0.00							
QC									
Quality Control	**Memo**	0.00							

5/11/08/11 ①

CK 5/08/12

#11-084 ①

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 11, 2011 9:51:17 AM

Work Order ID: 69429

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 5/11/2011 **Required Date:** 5/13/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev:J 05.09.02 Added D3442-1 □KJ/JLM
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1		Manufactured	No			100	Each	22.0000	1	1			
Rib													

Location	Loc Qty	Loc Code
WA	12	
69261	12	
WA006	10	
67465	10	

D2221-5		Manufactured	No			100	Each	8.0000	2	2			
Rib													

Location	Loc Qty	Loc Code
WA006	8	
67117	2	
67399	6	

D2221-7		Manufactured	No			100	Each	4.0000	1	1			
Rib													

Location	Loc Qty	Loc Code
WA006	4	
67274	4	

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 11, 2011 9:51:17 AM

3

Work Order ID: 69429

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 5/11/2011 **Required Date:** 5/13/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2232-3	Manufactured	No		100	Each	16.0000	2	2

Basket Hinge

Location	Loc Qty	Loc Code
WA005	16	
69211	16	

B71796 → (2)

D2235-1	Manufactured	No		100	Each	16.0000	2	2

Basket Rib

Location	Loc Qty	Loc Code
WA	10	
68606	10	
WA005	6	
66895	6	

B71540 → (2)

D2581	Manufactured	No		100	Each	38.0000	2	2

Mounting Bracket

Location	Loc Qty	Loc Code
WA	38	
68964	38	

B70766 → (2)

D3442-1	Manufactured	No		100	Each	11.0000	2	2

Shim

Location	Loc Qty	Loc Code
WA005	11	
64271	2	
65783	9	

B71224 → (2)

D3825-041	Manufactured	No		100	Each	0.0000	2	2

Rib Assembly (Basket End)

B70843 → (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Picklist Print

Wednesday, May 11, 2011 9:51:17 AM

Work Order ID: 69429

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 5/11/2011 **Required Date:** 5/13/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3826-041	Manufactured	No		100	Each	0.0000	2	2

Rib / Gusset Assembly

B70844 → (2) fpl 11.08.09

D3827-041	Manufactured	No		100	Each	3.0000	1	1

Rib Assembly (Inboard)

fpl 11.08.09

Location	Loc Qty	Loc Code
WA006	3	
67275	3	

B70675 → (1)

D3832-1	Manufactured	No		100	Each	2.0000	1	1

Mesh (Base)

fpl 11.8.9

Location	Loc Qty	Loc Code
WA	2	
67477	2	

B71844 → (1)

D3833-1	Manufactured	No		100	Each	13.0000	2	2

Mesh (Base End Face)

fpl 11.8.9

Location	Loc Qty	Loc Code
WA	13	
65937	4	
67459	9	

B71834 → (2)

Dart Aerospace Ltd

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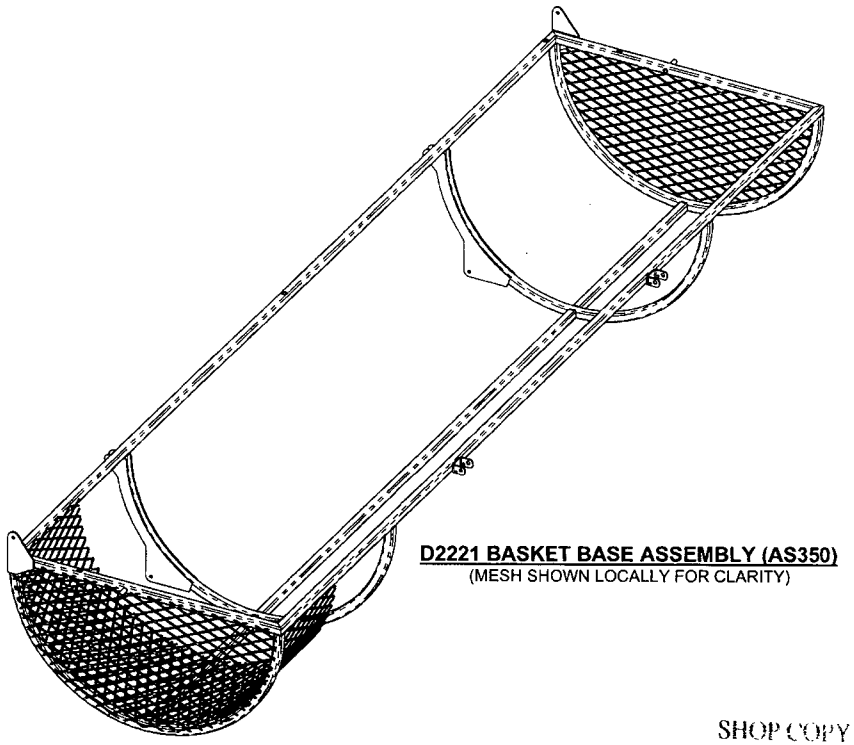
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ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	**BASKET BASE ASSEMBLY (AS350)**
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

REVISED 08/11/18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 09429

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: 42.00 lbs APPROX
9) MASK ALL HOLES PRIOR TO POWDER COATING

REV.	DESCRIPTION	BY	DATE
H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3625-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2221 REV. H
MFG. APPR.		SHEET 1 OF 5
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
DE APPR.		
DATE	08.09.18	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

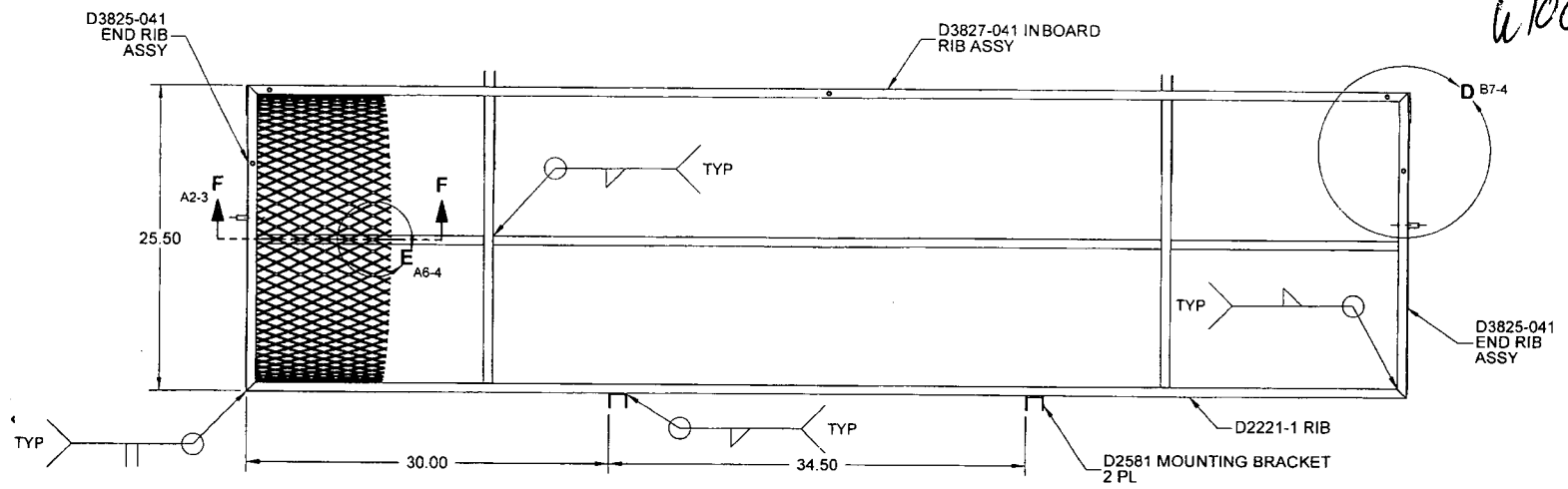
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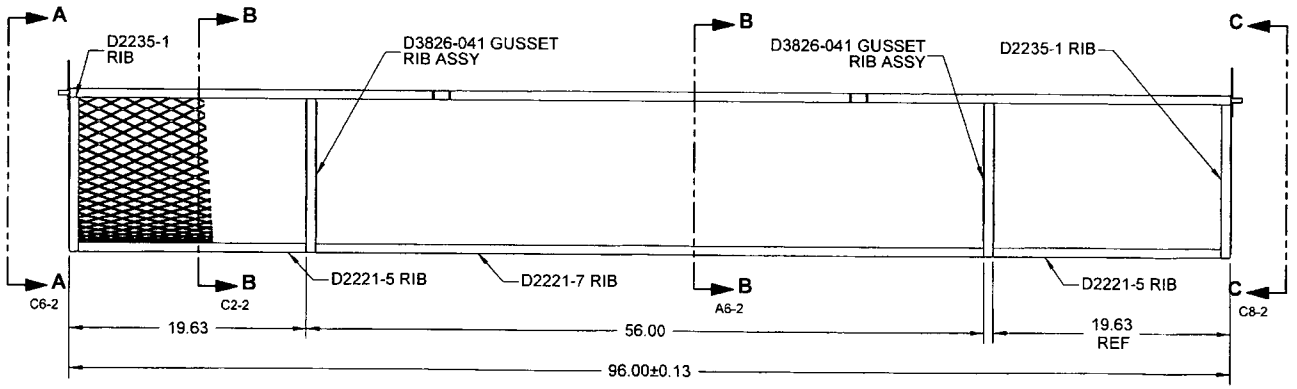
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

w/oc9429





RELEASED 06/11/18 NJD

D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2221 REV. H
MFG. APPR.		SHEET 2 OF 5
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
DE APPR.		
DATE 08.09.18		

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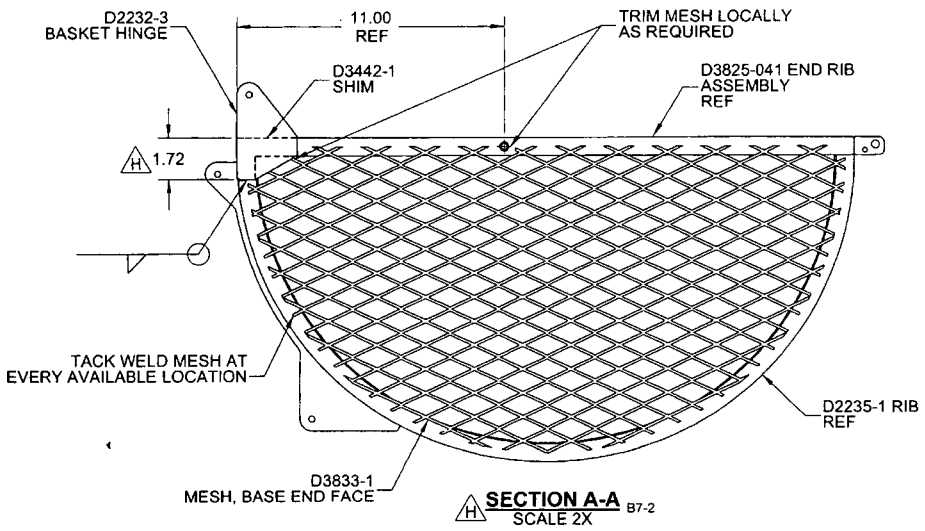
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DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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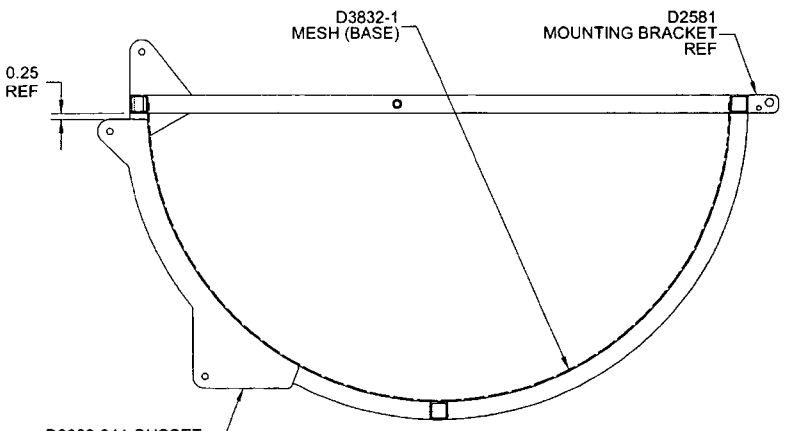
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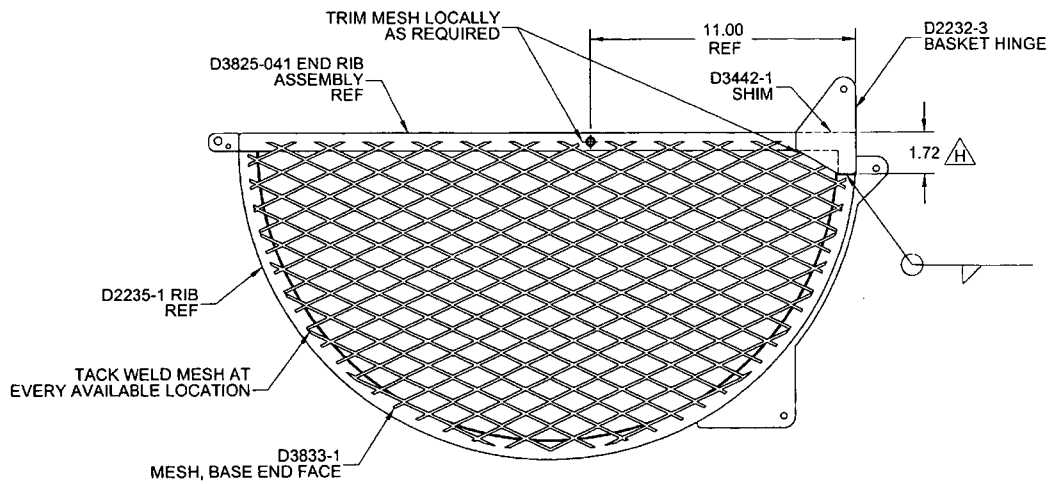
NOTE: Date & initial all entries



H **SECTION A-A** B7-2
SCALE 2X



H **SECTION B-B** B6-2 B4-2
(D3833-1 MESH NOT SHOWN FOR CLARITY)
SCALE 2X



H **SECTION C-C** B2-2
SCALE 2X

abc9429

RELEASED
05/11/18

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2221 REV. H SHEET 3 OF 5
MFG. APPR.		
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
DE APPR.		
DATE	08.09.18	

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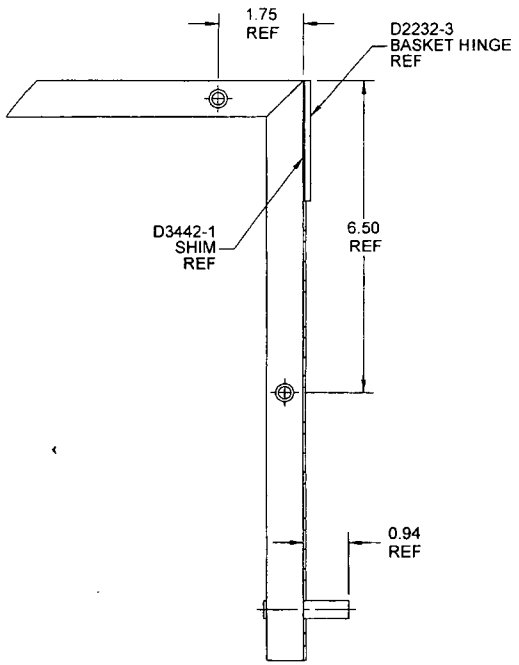
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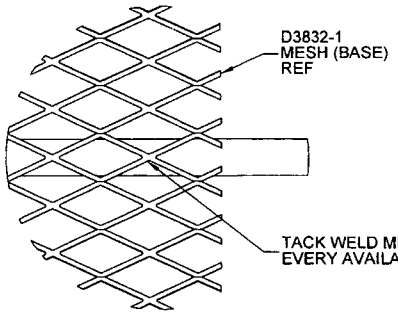
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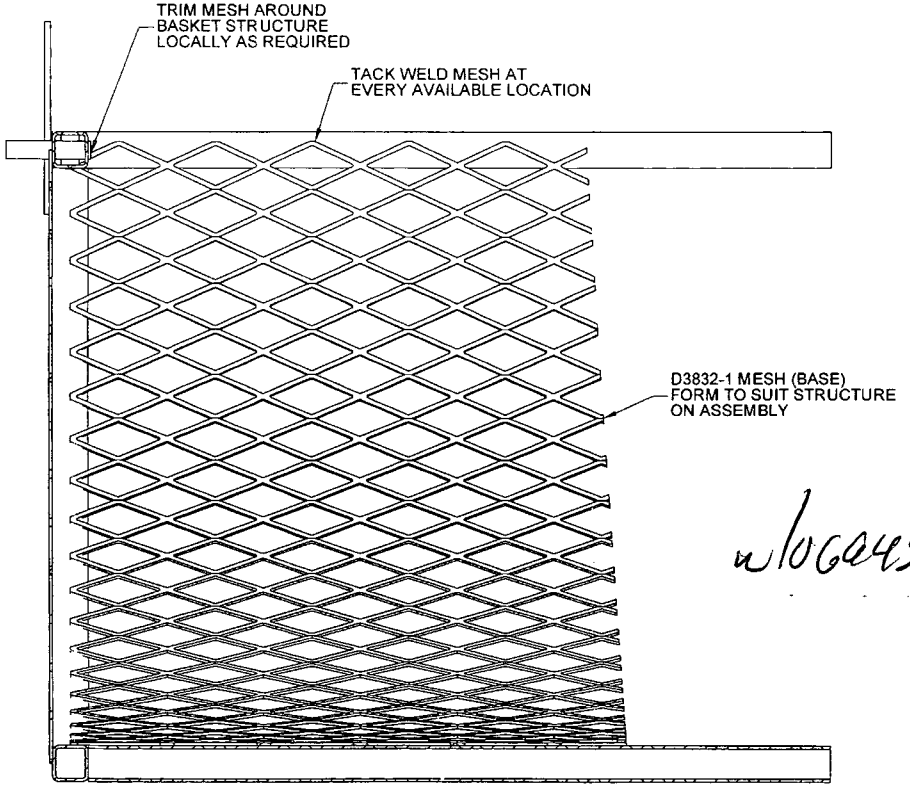
NOTE: Date & initial all entries



H DETAIL D SCALE 4X D2-2



H DETAIL E SCALE 4X C6-2



H SECTION F-F SCALE 4X D7-2

w/ 060429

RELEASED 02/11/16 MD

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2221 REV. H
MFG. APPR.		SHEET 4 OF 5
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
DE APPR.		
DATE	08.09.18	

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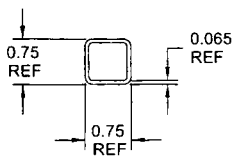
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

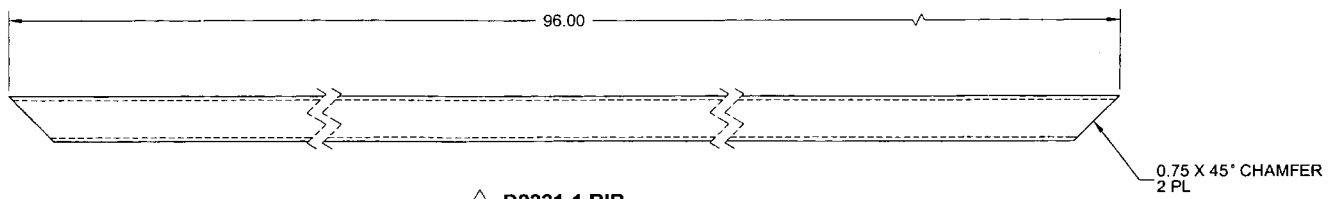
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

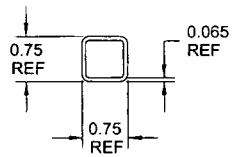
NOTE: Date & initial all entries

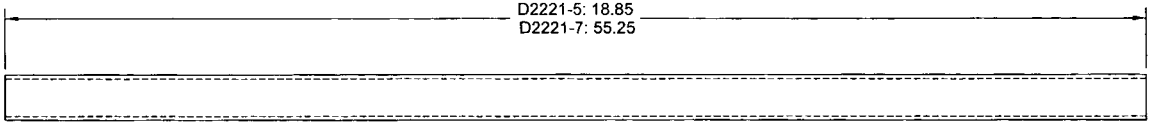




△H **D2221-1 RIB**

wb 69439





△H **D2221-5/-7 RIB**

RELEASED
08/11/18 JW

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT:D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D2221 REV. H
CHECKED		SHEET 5 OF 5
MFG. APPR.		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
APPROVED		
DE APPR.		
DATE	08.09.18	

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries